

Work Order ID 71866

Wednesday, July 13, 2011 11:02:10 AM



Page 1

Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 7/14/2011 Start Qty: 4.00

Required Date: 7/28/2011 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-07-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2932

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

29 11-8-3

8

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

29 11-8-3

8

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

29 11-8-3

8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 71866

Wednesday, July 13, 2011 11:02:10 AM



Page 2

Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

OK 11/08/08



QC

Memo

0.00

Quality Control

8 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8x 0 m 11/08/08

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *1:00pm* OVEN TEMPERATURE:
FINISH TIME: *1:20pm* *320°F*

8 0 11/08/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 71866

Wednesday, July 13, 2011 11:02:10 AM

Page 3

Item ID: D2932-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle RH Out, 206

Start Date: 7/14/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8x 0 M-11/08/08

170

Identify as per dwg & Stock Location: 428

0.00



Packaging

Memo

0.00

Packaging

4/1/08/2

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/10

11-08-9
(8)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, July 13, 2011 11:02:07 AM

Work Order ID: 71866



Parent Item: D2932-2



Parent Item Name: Saddle RH Out, 206


Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC
IPP Rev:C As per Rev C 07-03-19 JLM □

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------------------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-003  Saddle Billet, 7075 | | Manufactured | No | | | 100 | Each | 11.0000 | 1 | 4 | | | |



29 11.8.3

Location

Loc Qty

Loc Code

MAT040

1

69678

1

MAT44

10

70978

10

1 (1)

||||| (7)

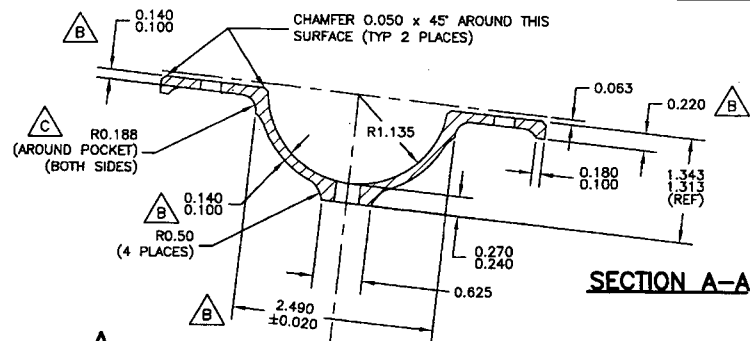
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

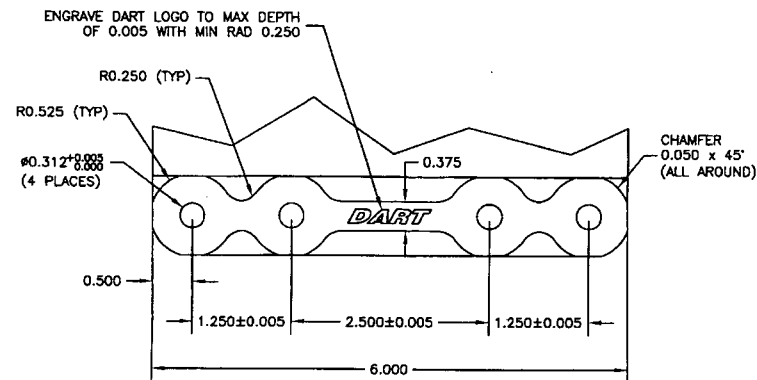
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



SECTION A-A



VIEW C-C

#71806

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

| | | |
|---------|----------|-------------------------------|
| C | 06.11.09 | R0.188 WAS R0.30 TO R0.25 |
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.10.29 | NEW ISSUE |
| DESIGN | 4 | DRAWN BY |
| CHECKED | PH | APPROVED |
| DATE | 06.11.09 | TITLE |
| | | SADDLE OUTSIDE |
| | | SCALE |
| | | 2:3 |

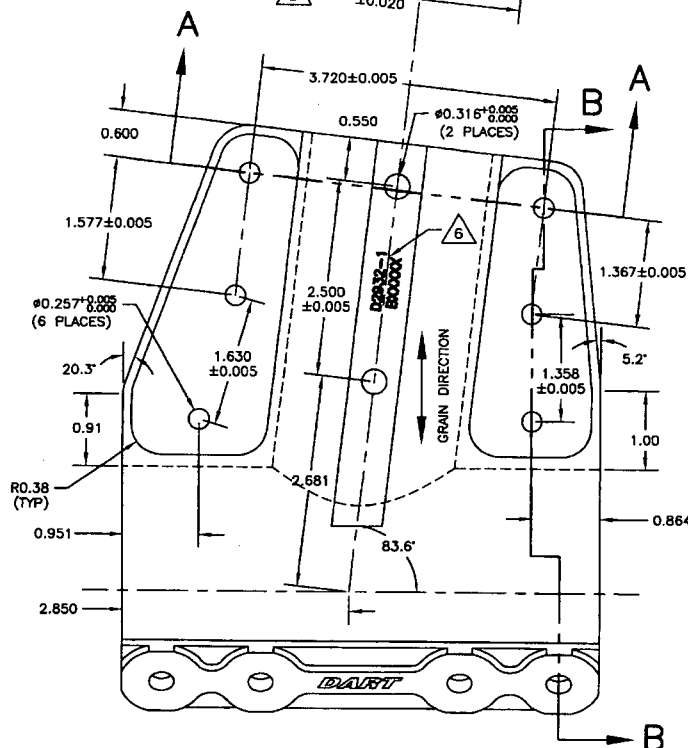
COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

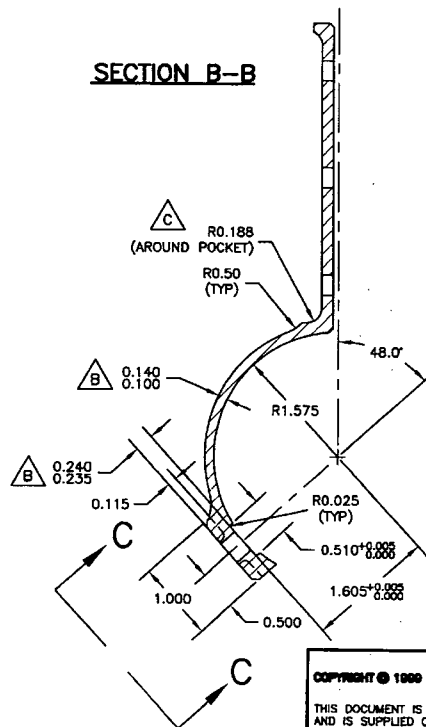
DART DART AEROSPACE USA, INC.
BOLLEVILLE, WA

DRAWING NO.
D2932

REV. C
SHEET 1 OF 1



SECTION B-B



RELEASED

07-02-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|------------------------------------------------------|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 71866 |
| Description: 206 Saddle, Outboard, Right side | | Part Number: | D2932-2 |
| Inspection Dwg: D2932 Rev. C | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

| Dim | Min | Max | Recorded Actual Dimensions | | | | | | | |
|---------------|-------|-------|----------------------------|-------|-------|-------|-------|---------|-----------|----------------|
| | | | Go/No Go S Gauge 6 | 1 | 2 | 3 | 4 | 7 By | 8 Date | |
| A | 0.100 | 0.140 | .109 | .109 | .109 | .109 | .109 | .109 | .109 | 29.02 |
| B | 0.100 | 0.140 | .109 | .108 | .108 | .108 | .108 | .108 | .108 | |
| C | 0.100 | 0.140 | .116 | .116 | .115 | .115 | .115 | .115 | .115 | |
| D | 0.210 | 0.230 | .215 | .215 | .215 | .215 | .215 | .215 | .215 | |
| E | 1.245 | 1.255 | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 | |
| F | 1.245 | 1.255 | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 | |
| G | 2.495 | 2.505 | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 | |
| H | 0.510 | 0.515 | .511 | .511 | .511 | .511 | .511 | .511 | .511 | |
| I | 1.572 | 1.582 | 1.577 | 1.577 | 1.577 | 1.577 | 1.577 | 1.577 | 1.577 | |
| J | 2.495 | 2.505 | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 | |
| K | 0.257 | 0.262 | .257 | .257 | .257 | .257 | .257 | .257 | .257 | |
| L | 0.312 | 0.317 | .313 | .313 | .313 | .313 | .313 | .313 | .313 | |
| M | 0.235 | 0.240 | .238 | .238 | .238 | .238 | .238 | .238 | .238 | |
| N | 0.100 | 0.140 | .106 | .106 | .106 | .106 | .106 | .106 | .106 | 20.06 29.02 |
| O | 0.540 | 0.560 | .550 | .550 | .550 | .550 | .550 | .550 | .550 | |
| P | 0.490 | 0.510 | .503 | .503 | .503 | .503 | .503 | .503 | .503 | |
| Q | 3.715 | 3.725 | 3.720 | 3.720 | 3.720 | 3.720 | 3.720 | 3.720 | 3.720 | |
| R | 2.470 | 2.510 | 2.495 | 2.495 | 2.495 | 2.495 | 2.495 | 2.495 | 2.495 | |
| S | 0.240 | 0.270 | .250 | .250 | .250 | .250 | .250 | .250 | .250 | |
| T | 0.100 | 0.180 | .140 | .140 | .140 | .140 | .140 | .140 | .140 | |
| U | 1.625 | 1.635 | 1.630 | 1.630 | 1.630 | 1.630 | 1.630 | 1.630 | 1.630 | |
| V | 1.362 | 1.372 | 1.367 | 1.367 | 1.367 | 1.367 | 1.367 | 1.367 | 1.367 | |
| W | 0.316 | 0.321 | .316 | .316 | .316 | .316 | .316 | .316 | .316 | |
| X | 1.125 | 1.145 | 1.129 | 1.129 | 1.129 | 1.129 | 1.129 | 1.129 | 1.129 | |
| Y | 1.565 | 1.585 | 1.569 | 1.569 | 1.569 | 1.569 | 1.569 | 1.569 | 1.569 | |
| Z | 0.178 | 0.198 | .188 | .188 | .188 | .188 | .188 | .188 | .188 | |
| AA | | | | | | | | | | |
| AB | | | | | | | | | | |
| AC | | | | | | | | | | |
| AD | | | | | | | | | | |
| AE | | | | | | | | | | |
| AF | | | | | | | | | | |
| AG | | | | | | | | | | |
| AH | | | | | | | | | | |
| Accept/Reject | | | | | | | | | | |

| | |
|--------------|--------|
| Measured by: | RP |
| Date: | 11.8.3 |

| | |
|-------------|----------|
| Audited by: | cmf |
| Date: | 11/08/08 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------------------------|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries